

Wednesday, November 03, 2010 10:40:29 A

Page 1

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Date:

**Insp.
Stamp**

Rev E

0.00

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. R63501 Double check by: [Signature] ☐ 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-
Machine Step No 3 per Folio FA051 and insp

0.00

0.00 / A-14 10/12/02

12

④

0.00

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2573 & D2574

0.00

B.A 10/12/14

12

Q

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

0.00

D.A 10/12/08

15

Q

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Work Order ID 63501




Wednesday, November 03, 2010 10:40:29 A



Page 2

Item ID: D2573 Accept  Setup Start 
Revision ID: Stop 
Item Name: Saddle, Aft Out 205
Start Date: 11/3/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 11/17/2010 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|----------------------|--------------|---------------|--------------------|------------------|----------------|
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | <i>conf 10/12/17</i> | | <i>12</i> | <i>0</i> | | |
| 140  HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | <i>⇒ H 10/12/17</i> | | <i>12</i> | <i>0</i> | | |
| 150  Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>2:10</i> <i>3:00</i> FINISH TIME: <i>2:40</i> | 0.00 0.00 | | | | <i>12</i> | <i>BR 10-12-20</i> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 63501

Wednesday, November 03, 2010 10:40:29 A

Page 3

Item ID: D2573

Accept

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 11/3/2010 Start Qty: 12.00

Required Date: 11/17/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 (12)

10/12/21

MF 10-12-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 10:40:39 AM

Page 1

Work Order ID: 63501

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205



Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D6101-007

Manufactured

No

100

Each

42.0000

1

12



Saddle Billet

Location

Loc Qty

Loc Code

MAT42

42

46412

2

✓62713

40

12.0

B.A 10/12/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 43501 |
| Description: Saddle, Aft Outboard | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|------|---------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.440 | 0.440 | 0.440 | 0.440 | Vern | GA-01 |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | " | " |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.002 | 8.002 | Vern | CNC-02 |
| F | 0.490 | 0.510 | | 0.502 | 0.501 | 0.501 | 0.501 | Vern | GA-01 |
| G | 0.257 | 0.262 | | 0.260 | 0.260 | 0.260 | 0.260 | " | " |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | " | " |
| I | 0.490 | 0.510 | | 0.501 | 0.501 | 0.501 | 0.501 | " | " |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| K | 0.558 | 0.578 | | 0.570 | 0.570 | 0.570 | 0.570 | " | " |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | " | " |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | " | " |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | " | " |
| P | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | Mic | GA-03 |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | Vern | GA-01 |
| R | 0.240 | 0.260 | | 0.253 | 0.253 | 0.253 | 0.253 | " | " |
| S | 0.115 | 0.135 | | 0.120 | 0.121 | 0.123 | 0.121 | Mic | 118-120 |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | R-6 | ref. |
| U | 3.210 | 3.250 | | 3.228 | 3.228 | 3.228 | 3.228 | Vern | GA-01 |
| V | 0.230 | 0.250 | | 0.242 | 0.241 | 0.242 | 0.242 | " | " |
| W | 0.115 | 0.135 | | 0.122 | 0.122 | 0.121 | 0.122 | Mic | 118-120 |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | Vern | GA-01 |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | " | " |
| Z | 0.352 | 0.372 | | 0.363 | 0.363 | 0.363 | 0.362 | " | " |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | R-6 | ref |
| AB | 0.615 | 0.635 | | 0.627 | 0.627 | 0.627 | 0.627 | Vern | GA-01 |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | R-6 | ref |
| AD | 0.240 | 0.260 | | 0.246 | 0.246 | 0.246 | 0.246 | Vern | GA-01 |
| AE | 1.500 | 1.520 | | 1.513 | 1.5124 | 1.5143 | 1.5134 | Dial | HAAS3 |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | Vern | GA-01 |
| AG | 0.240 | 0.280 | | 0.250 | 0.250 | 0.250 | 0.250 | " | " |
| AH | 0.240 | 0.260 | | 0.245 | 0.251 | 0.251 | 0.251 | " | " |
| AI | 2.000 | 2.020 | | 2.0037 | 2.0015 | 2.0025 | 2.0019 | Dial | HAAS3 |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | R-6 | ref. |
| Accept/Reject | | | | | | | | | |

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| Measured by: | K.R. |
| Date: | 10/12/08 |

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|-------------|----------|
| Audited by: | Ork |
| Date: | 10/12/12 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 43501 |
| Description: Saddle, Aft Outboard | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|-------|--------|------|---------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 76 | 77 | 78 | By | Date |
| A | 0.438 | 0.443 | | 0.440 | 0.440 | 0.440 | 0.440 | Vern | GA-01 |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | " | " |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| E | 7.990 | 8.010 | | 8.002 | 8.001 | 8.001 | 8.002 | Vern | CNC-02 |
| F | 0.490 | 0.510 | | 0.501 | 0.501 | 0.501 | 0.502 | Vern | GA-01 |
| G | 0.257 | 0.262 | | 0.260 | 0.260 | 0.260 | 0.260 | " | " |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | " | " |
| I | 0.490 | 0.510 | | 0.501 | 0.501 | 0.501 | 0.501 | " | " |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| K | 0.558 | 0.578 | | 0.570 | 0.570 | 0.570 | 0.570 | " | " |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | " | " |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | " | " |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | " | " |
| P | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | M.C | GA-03 |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | Vern | GA-01 |
| R | 0.240 | 0.260 | | 0.253 | 0.253 | 0.253 | 0.253 | " | " |
| S | 0.115 | 0.135 | | 0.122 | 0.122 | 0.121 | 0.123 | M.C | 112-120 |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | R-6 | ref. |
| U | 3.210 | 3.250 | | 3.228 | 3.228 | 3.228 | 3.228 | Vern | GA-01 |
| V | 0.230 | 0.250 | | 0.242 | 0.242 | 0.242 | 0.241 | " | " |
| W | 0.115 | 0.135 | | 0.121 | 0.122 | 0.122 | 0.122 | M.C | 112-120 |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | Vern | GA-01 |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | " | " |
| Z | 0.352 | 0.372 | | 0.363 | 0.362 | 0.362 | 0.362 | " | " |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | R-6 | ref. |
| AB | 0.615 | 0.635 | | 0.627 | 0.627 | 0.627 | 0.627 | Vern | GA-01 |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | R-6 | ref. |
| AD | 0.240 | 0.260 | | 0.246 | 0.248 | 0.246 | 0.246 | Vern | GA-01 |
| AE | 1.500 | 1.520 | | 1.512 | 1.5115 | 1.512 | 1.5116 | Dial | HAAS3 |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | Vern | GA-01 |
| AG | 0.240 | 0.280 | | 0.250 | 0.250 | 0.250 | 0.250 | " | " |
| AH | 0.240 | 0.260 | | 0.251 | 0.252 | 0.251 | 0.251 | " | " |
| AI | 2.000 | 2.020 | | 2.0028 | 2.0015 | 2.002 | 2.0032 | Dial | HAAS3 |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | R-6 | ref. |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | B.A |
| Date: | 10/12/14 |

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|-------------|----------|
| Audited by: | CMF |
| Date: | 10/12/17 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

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|--|--|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 43501 |
| Description: Saddle, Aft Outboard | | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|------|--------|
| Dim | Min | Max | Go/No Go Gauge | #9 | #10 | #11 | #12 | By | Date |
| A | 0.438 | 0.443 | | 0.440 | 0.440 | 0.440 | 0.440 | Vern | GA-01 |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | " | " |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | " |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.001 | 8.003 | Vern | CNL-02 |
| F | 0.490 | 0.510 | | 0.499 | 0.501 | 0.500 | 0.501 | Vern | GA-01 |
| G | 0.257 | 0.262 | | 0.260 | 0.260 | 0.260 | 0.260 | " | " |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | " | " |
| I | 0.490 | 0.510 | | 0.501 | 0.501 | 0.501 | 0.501 | " | " |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| K | 0.558 | 0.578 | | 0.570 | 0.570 | 0.570 | 0.570 | " | " |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | " |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | " | " |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | " | " |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | " | " |
| P | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | Mic | GA-03 |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | Vern | GA-01 |
| R | 0.240 | 0.260 | | 0.253 | 0.253 | 0.253 | 0.253 | " | " |
| S | 0.115 | 0.135 | | 0.122 | 0.123 | 0.122 | 0.121 | Mic | HB-120 |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.180 | R-6 | ref. |
| U | 3.210 | 3.250 | | 3.228 | 3.228 | 3.228 | 3.228 | Vern | GA-01 |
| V | 0.230 | 0.250 | | 0.242 | 0.242 | 0.242 | 0.242 | " | " |
| W | 0.115 | 0.135 | | 0.121 | 0.122 | 0.121 | 0.121 | Mic | HB-120 |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | Vern | GA-01 |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | " | " |
| Z | 0.352 | 0.372 | | 0.363 | 0.361 | 0.364 | 0.362 | " | " |
| AA | 0.470 | 0.530 | | 0.500 | 0.506 | 0.500 | 0.500 | R-6 | ref. |
| AB | 0.615 | 0.635 | | 0.627 | 0.627 | 0.627 | 0.627 | Vern | GA-01 |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | R-6 | ref. |
| AD | 0.240 | 0.260 | | 0.246 | 0.246 | 0.246 | 0.246 | Vern | GA-01 |
| AE | 1.500 | 1.520 | | 1.5117 | 1.5117 | 1.512 | 1.512 | Dial | HAAS3 |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.125 | 0.125 | Vern | GA-01 |
| AG | 0.240 | 0.280 | | 0.250 | 0.250 | 0.250 | 0.250 | " | " |
| AH | 0.240 | 0.260 | | 0.251 | 0.252 | 0.251 | 0.251 | " | " |
| AI | 2.000 | 2.020 | | 2.0027 | 2.0027 | 2.0026 | 2.0025 | Dial | HAAS3 |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | R-6 | ref. |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | D.A |
| Date: | 10/12/15 |

| | |
|-------------|----------|
| Audited by: | CML |
| Date: | 10/12/17 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

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UNCONTROLLED CO.

SUBJECT TO AMENDMENT

WITHOUT NOTICE RELEASED

WORK ORDER 05.10.06 #

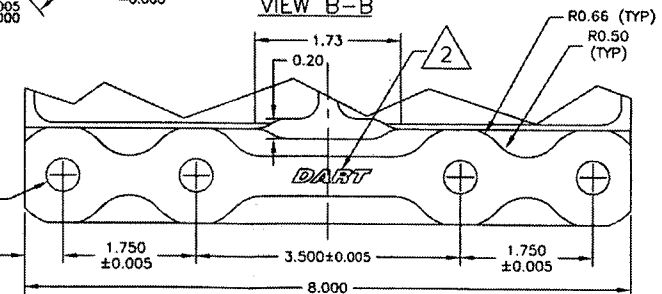
NO. 13501

NOTES

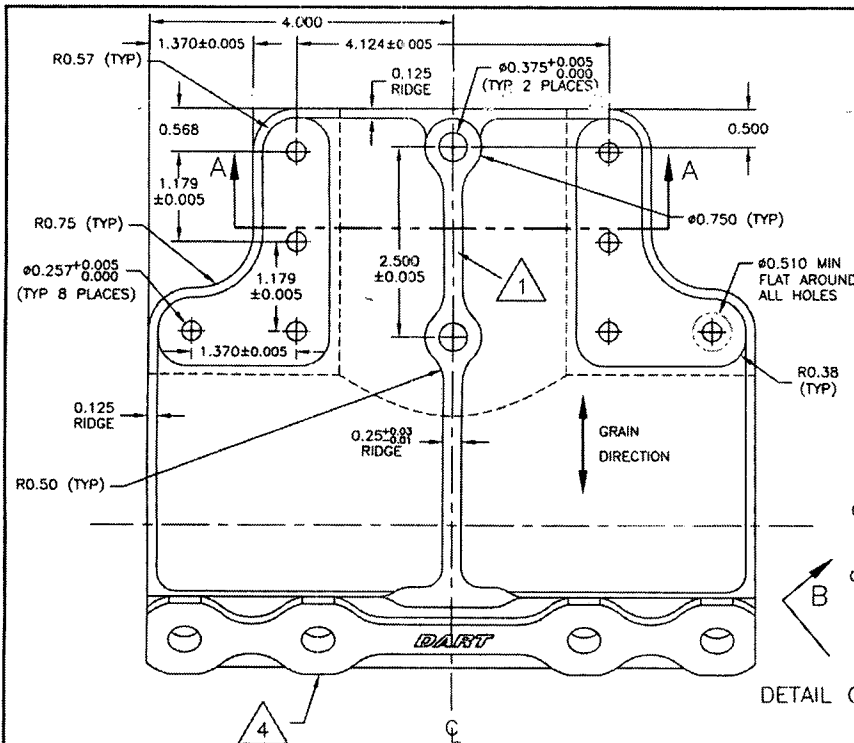
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

VIEW B-B

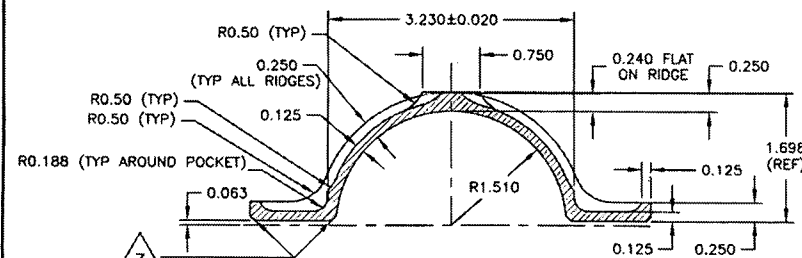


| | | |
|---|----------|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 5 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |



DETAIL C

SCALE 4:3



SECTION A-A

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| | | | | | |
|---------|----------|----------|------------------|-------------|---|
| DESIGN | DS | DRAWN BY | PH | DART | DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | D2573 |
| DATE | 05.07.13 | TITLE | OUTER AFT SADDLE | REV. E | SHEET 1 OF 1 |
| | | | | SCALE | 2:3 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries